

Date: Monday, 12/01/2009 2:38:38 PM  
User: Julie Dawson

## Process Sheet

|  |   |
|--|---|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services<br><b>Job Number</b> : 44696<br><b>Estimate Number</b> : 13536<br><b>P.O. Number</b> :<br><b>This Issue</b> : 12/01/2009 <b>S.O. No.</b> :<br><b>Prsht Rev.</b> : NC<br><b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS<br><b>Previous Run</b> : 44179<br><b>Written By</b> :<br><b>Checked &amp; Approved By</b> : <u>JUD 09.01.13</u><br><b>Comment</b> : Est Rev:A NEW ISSUE 08-08-01 JLM    Verified By:DD | <b>Drawing Name</b> : SLIDING BLOCK<br><br><b>Part Number</b> : D38091<br><b>Drawing Number</b> : D3809 REV A<br><b>Project Number</b> : N/A<br><b>Drawing Revision</b> : A<br><b>Material</b> :<br><b>Due Date</b> : 30/01/2009 <b>Qty:</b> 20 <b>Um:</b> Each |
|--|---|

### Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |                   |                         |
|-----|-------------------|-------------------------|
| 1.0 | MDLRINB0250X01000 | Delrin Bar 0.25" x 1.0" |
|-----|-------------------|-------------------------|

**Comment:** Qty.: 0.1575 f(s)/Unit    Total : 1.5750 f(s)

Delrin Bar 0.25" x 1.0"

BATCH: ~~M103034~~ M110887 3'

(20)

88 09/02/21

|     |       |       |
|-----|-------|-------|
| 2.0 | SHEAR | SHEAR |
|-----|-------|-------|

**Comment:** SHEAR

Cut Blanks 1.850" long

(20)

88 09/02/21

|     |       |                                |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|

**Comment:** HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA770 Rev: AA & Dwg D3809 Rev: A

2-Deburr per dwg D3809

09/02/22 (20)  
J.F. ✓

|     |     |  |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

09/02/22 (20)  
J.F. ✓





|     |     |              |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|

**Comment:** SECOND CHECK

09/02/20 (20)  
J.F. ✓

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: D3809-1 PAR #: N/A Fault Category: Prod/Machined Parts NCR: Yes No DQA: D Date: 09/03/03  
 Resolution: D380-681013 Scrap Disposition: Scrap QA: N/C Closed: D Date: 09/03/03

| NCR: <u>44696</u> |                                  | WORK ORDER NON-CONFORMANCE (NCR)  |  |                                     |                  |  |  |  |
|-------------------|----------------------------------|---|--|-------------------------------------|------------------|--|--|--|
| DATE              | STEP                             | Description of NC<br>Section A  | Corrective Action Section B  |                                     |                  | Verification<br>Section C  | Approval<br>Chief Eng  | Approval<br>QC Inspector   |
|                   |                                  |   | Initial<br>Chief Eng   | Action Description<br>Chief Eng     | Sign &<br>Date   |  |  |  |
| 09/02/20          | <del>2.0</del><br>2.0 and<br>3.0 | 20 parts are scrap,<br>wrong materiel. Parts<br>were cut and machined<br>with aluminum, suppose<br>to be Delrin.<br>R.C. Human error. |  | Scrap and replace<br>operator error | J.F.<br>09/02/20 |  |  |  |
|                   |                                  |   |  |                                     |                  |  |  |  |
|                   |                                  |   |  |                                     |                  |  |  |  |

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:38:39 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLIDING BLOCK

Job Number: 44696

Part Number: D38091

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

STIAL

AS 09/02/20

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/26

Job Completion



U 09-02-26

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

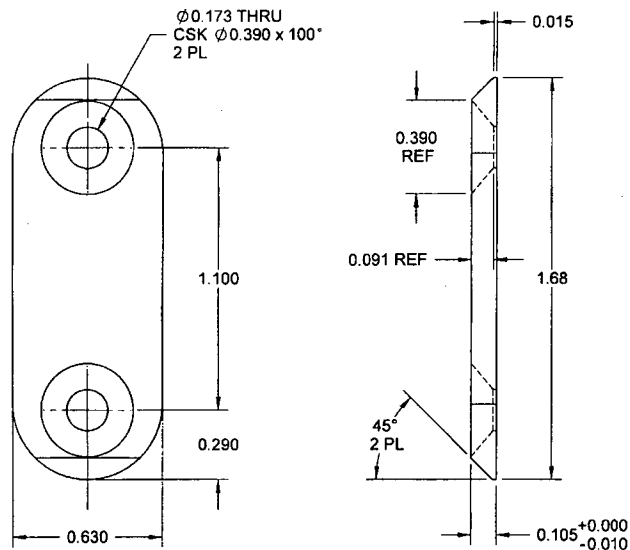
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries





**D3809-1 SLIDING BLOCK**  
SCALE 2X

**NOTES:**

- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL SHEET OR BAR (REF. DART SPEC. M-DELIN-S OR M-DELIN-B)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.004 lbs

**RELEASED**  
08.07.24

|            |                    |   |  |    |              |
|------------|--------------------|---|--|----|--------------|
| A          |                    | NEW ISSUE   |  | RF | 08.07.24     |
| REV.       |                    | DESCRIPTION   |  |    | DATE         |
| DESIGN     | RF                 | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA<br><br>DRAWING NO. <b>D3809</b><br><br>TITLE<br><b>SLIDING BLOCK</b><br><br>COPYRIGHT © 2008 BY DART AEROSPACE LTD<br><small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> |  |    | REV. A       |
| DRAWN      | RF                 |   |  |    | SHEET 1 OF 1 |
| CHECKED    | <i>Ref</i>         |   |  |    | SCALE        |
| MFG. APPR. | <i>[Signature]</i> |   |  |    | NTS          |
| APPROVED   | <i>[Signature]</i> |   |  |    |              |
| DE APPR.   | <i>[Signature]</i> |   |  |    |              |
| DATE       | 08.07.24           |   |  |    |              |